

5/46

DART AEROSPACE LTD	Work Order:	24671
Description: 350 Skidtube Web	Part Number:	D2739
Drawing: D2739 Rev B	Qty:	6
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller RF 03.05.12 DWG NOT REQUIRED	KJ	05.10.26	6
2	LG	Pick: Qty Part Number Description Batch 1 D2600-5 Web B12433	Amc	05-11-14	6
3	LG	Cut D2600-5 to length as per Dwg D2739.	Amc	05-11-14	6
4	LG	Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	Amc	05-11-14	6
5	LG	Use uni-bit to open holes to finish size as per Dwg D2739.	Amc	05-11-14	6
6	LG	Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.	A.M.	05-11-14	6
7	FP	Acid Etch and Alodine per QSI 005 4.1	A.M.	05-11-14	6
8	LG	Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.			
9	QC5	Inspect for completeness on the W/O	DP	05-11-15	6
10	LG	Identify and Stock using a lead free paint pen	DP	05-11-15	6
11	AC	Cost / part 21.75	SUC	05-11-21	6
12	DC	Close W/O 21.77 Inspect Level 21	DP	05/11/21	6

Rev	Date	Change	Revised By	Approved
A	98.09.09	New Issue	DS/CP	
B	99.01.04	Drawing to Rev. B	DM	
C	02.11.28	Reformat	KJ / RF RF	

RELEASED
02/11/29 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 05/11/24

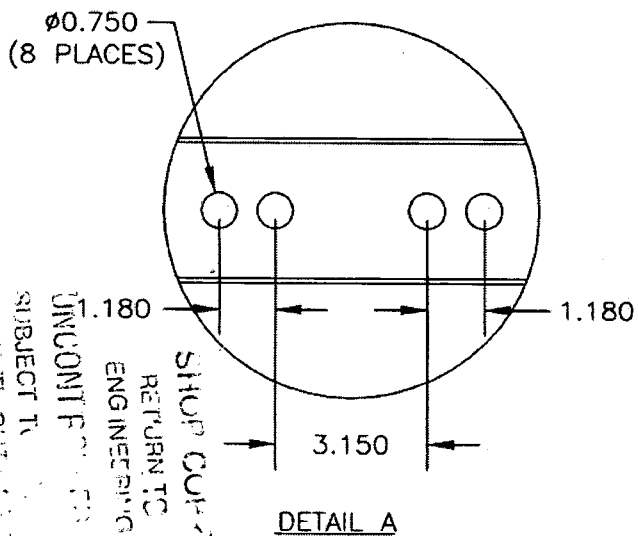
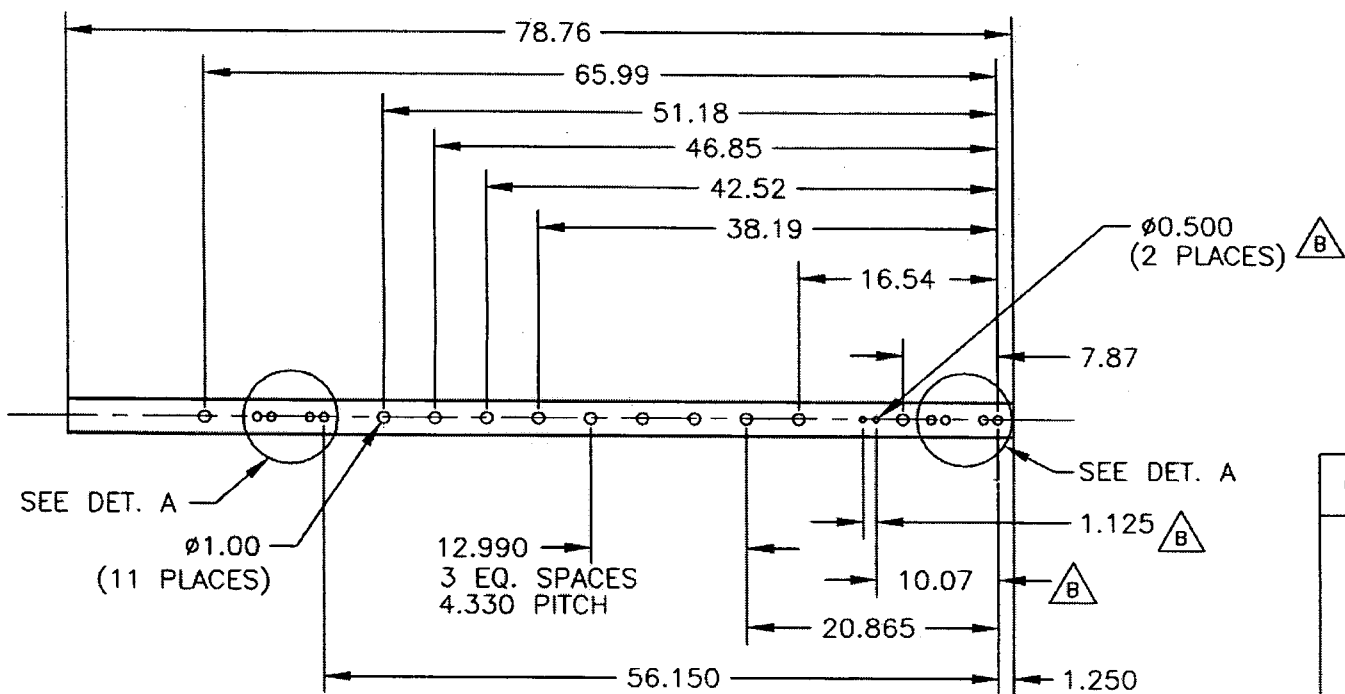
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	BELLEVUE, WA
DATE	TITLE	DRAWING NO.
98.11.18	WEB	D2739
	NEW ISSUE	REV. B
		SHEET 1 OF 1
		SCALE
		1:15
		CHANGE HOLES FOR COMPATABILITY WITH AIRCRAUISER FLOATS



MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
98.12.16 DS

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No : 0024671
Project Name : D2739
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D2739
Description : 350 I Beam
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:44 pm

Work Order No : 0024671
Project Name : D2739
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D2739
Description : 350 I Beam
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	4.00	100.00		
Production Cost :	0.00	62.00	100.00	0.00	62.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	62.00	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	62.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-62.00)

MIS 01/B
W
11.13

Date: Monday, 14/11/2005 8:11:53 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKITUBE WEB
Job Number :	24671		
Estimate Number :	10498		
P.O. Number :		Part Number :	D2739
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2739 REV B
First Issue :	//	Project Number :	
Previous Run :		Drawing Revision :	B
	Type :	Material :	
	LANDING GEAR	Due Date :	30/11/2005
Written By :		Qty:	6
Checked & Approved By :		Um:	Each
Comment :	Est. C 02.11.28 Reformat KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

5-Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Inspection Level 21



Job Completion

2-1-2014

2-1-2014

2-1-2014

2-1-2014